

## Grooving insert with facettes











A08-100

Grooving inserts with multiple clearance angles are used for deep cuts on round blanks. To cut a groove into the face of a cylindrical blank, the tool must provide pretty good clearance behind the cutting edge in order not to destroy the side wall of inner diameter when it feeds in or out.

The facettes on insert are ground using a rough periphery 1A1 wheel.



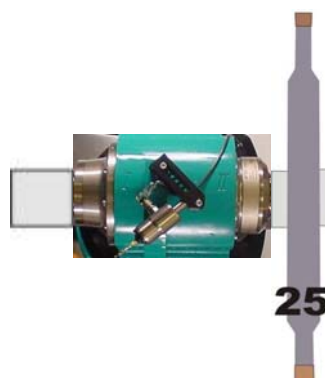
### 1. Cycletime for Production

Tool specifications						
Length of ground edge: 4x12mm, DXF-profile						
Material CARBIDE						
Operations						
Feed [mm/Min]	9000	100	100	100	100	9000
Power [kW]	1	2	2	2	2	1
Cutting feed [m/s]		100	100	100	100	
Used wheels						
Grinding time [s]	10	20	20	20	20	10
Total cycle time	1 Min 40 per side					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

25	1A1 Ø300 D64
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### 3. Machine and Software Requirements

Machines: 6 axes CNC grinder: SIRIUS HPM  
 Control: Fanuc 160i  
 Coolant: Synthetic Oil, pressure 6 bar  
 Software: Quinto 4.3, DXQ

responsible engineer: SIW 21.01.2009

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